

Work Order ID 80992

80992

Page 1

March-06-12 9:18:07 AM

Item ID: D2662-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, RH In 206
 Start Date: 06/03/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/06 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100 0.00
 100 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Program part number and batch number.
 Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG
 DWG REV: E
 FOLIO REV: AA

110 0.00
 110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

(Pto)

W/O: 80992

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D262-2 PAR #: _____ Fault Category: mechanics NCR: Yes No DQA: Not Date: 12/06/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12

NCR: 121474

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-05-17	100	changed out + 16 1" insert and mill for a 1" end mill because another machine required the insert end mill changed tool right for T16 but not forgot to do the offset H26 tool cut complete bottom section off where the saddle bolts to slid R.L. operate Error / WOP	<u>MB</u> 12/05/17 Q42042	scrap + replace B <u>83309</u> ON + 1	<u>HT</u> 12-05-17	<u>MB</u> 12/05/23	<u>MB</u> 12/05/17 Q42042	<u>S</u> 12/05/17

NOTE: Date & initial all entries

Page 2

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 80992

March-06-12 9:18:07 AM

80992

Page 4

Item ID: D2662-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 06/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

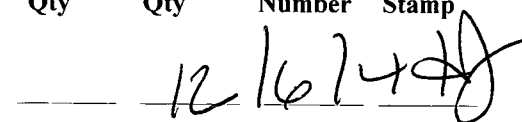
180

QC

Memo

0.00

Quality Control



MF

12-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 9:18:11 AM

Page 1

Work Order ID: 80992

80992

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured No

100

Each

63.0000

1

20

D6101-001

**

Saddle Billet

SL 12-05-14

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT045

60

79586

60

8309

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 80992	
Description: 206 Saddle, Inboard, Right side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.120	.123	.124	.126	
G	0.210	0.230		0.221	.221	.223	.219	
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.322	1.322	1.323	1.327	
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.137	1.138	1.138	1.141	
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.145		0.121	0.118	0.116	.119	
P	0.240	0.260		0.252	0.250	0.250	.251	
Q	0.677	0.697		0.690	.687	.687	.695	
R	0.540	0.560		0.552	0.555	0.552	.545	
S	0.912	0.932		0.926	0.925	0.926	.916	
T	0.787	0.807		0.803	0.806	0.800	.804	
U	5.990	6.010		6.001	6.003	6.001	5.999	
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.504	.499	.497	.501	
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.003	1.000	1.001	.999	
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.499	.502	.502	.501	
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.125	.132	.126	.130	
AE	0.235	0.240		.240	.240	.240	.240	
AF	0.510	0.515		.510	.510	.511	.511	
AG	0.100	0.120		.115	.117	.117	.118	
AH								
AI								

QC2-SL 12-05-14

QC8 OK 12/05/23

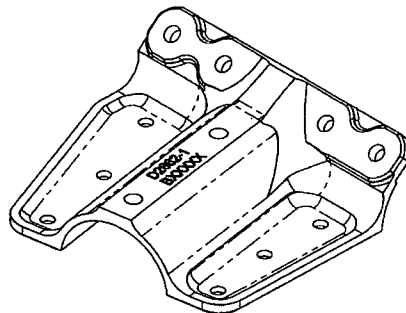
DART AEROSPACE LTD		Work Order:	80992
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

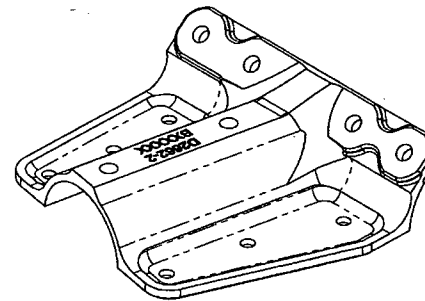
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:		Date:	
Audited by:	<i>ark</i>	Date:	12/05/23
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



D2662-1 SADDLE, INSIDE, LH



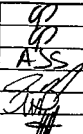
D2662-2 SADDLE, INSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 80992 MLJ
12/03/06

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.318 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9085/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	SADDLE, INSIDE	NTS	
DATE	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT MAY BE USED FOR ANY PURPOSE OR ON ANY BASIS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT NOTICE TO THE ISSUING OFFICE.		
	11.10.31		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

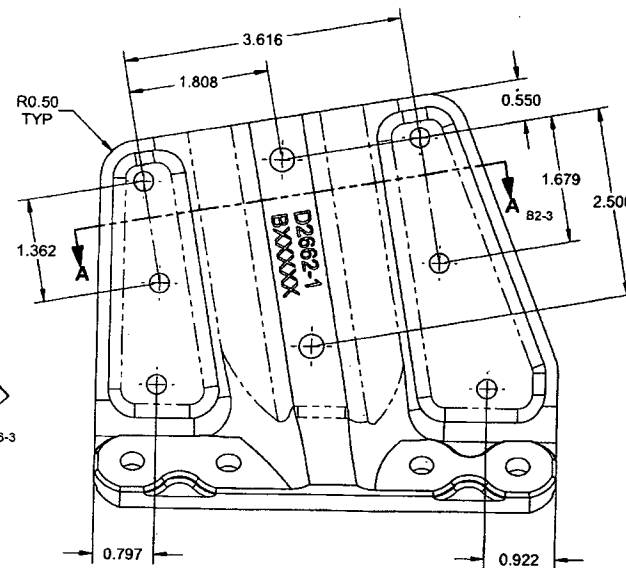
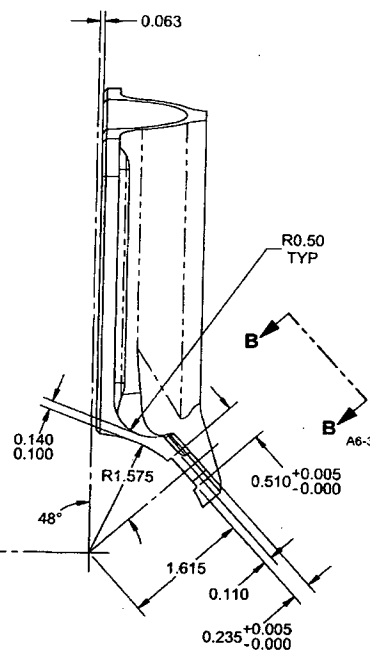
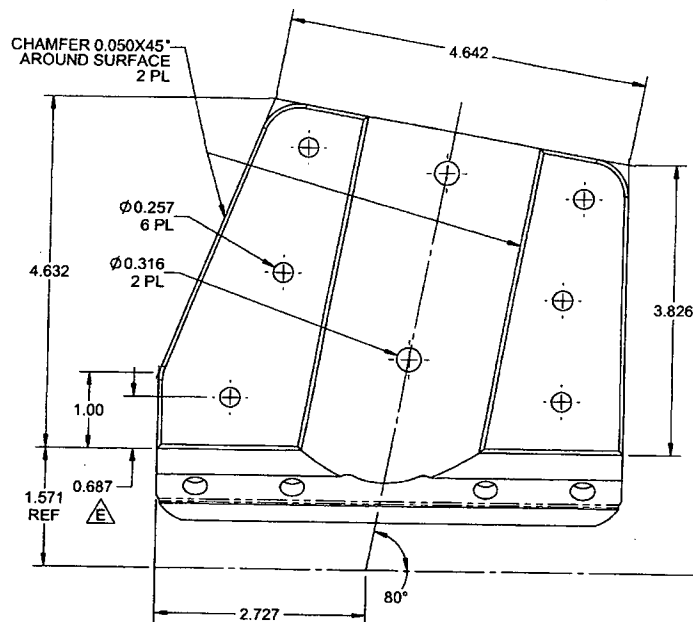
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80992



D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

RELEASE
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

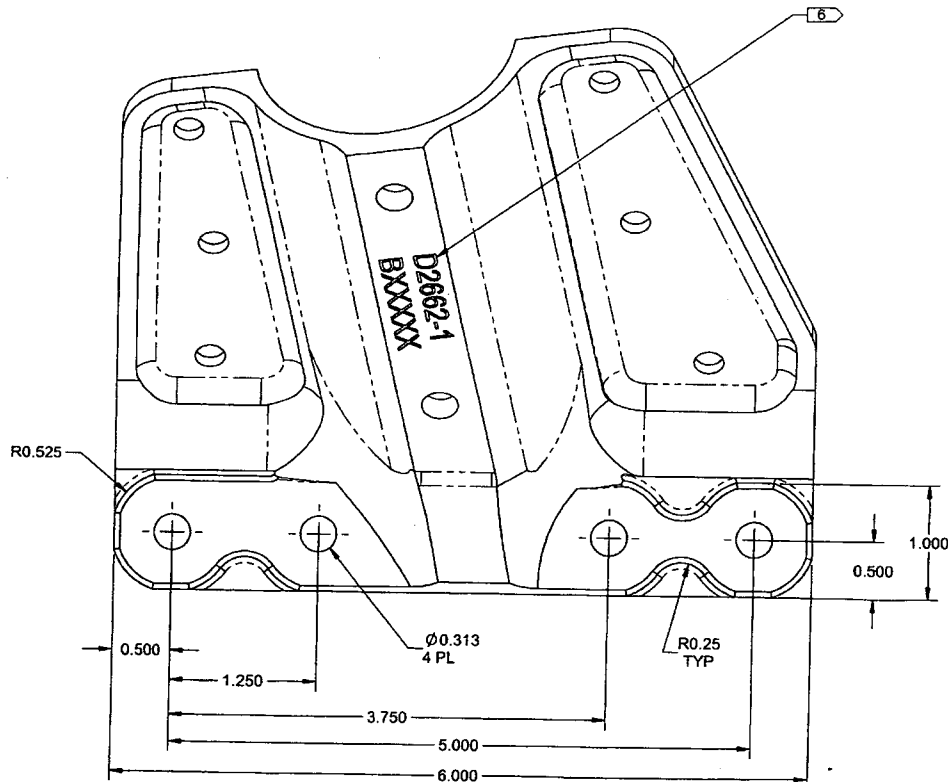
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

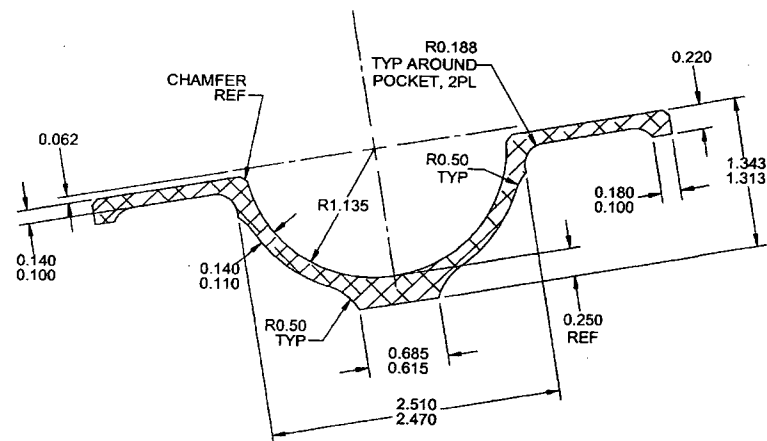
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80992



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C1-2

RELEASED
2011-11-16

DESIGN	42	DART AEROSPACE USA, INC.	
DRAWN	42	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	3/1/91	D2662	SHEET 3 OF 5
APPROVED	3/1/91	TITLE	SCALE
DE APPR.	3/1/91	SADDLE, INSIDE	NTS
DATE	11.10.31	<small> COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CHAMFER 0.050X45°
AROUND SURFACE
2 PL

4.642

3.826

1.571
REF

Ø0.257
6 PL

Ø0.316
2 PL

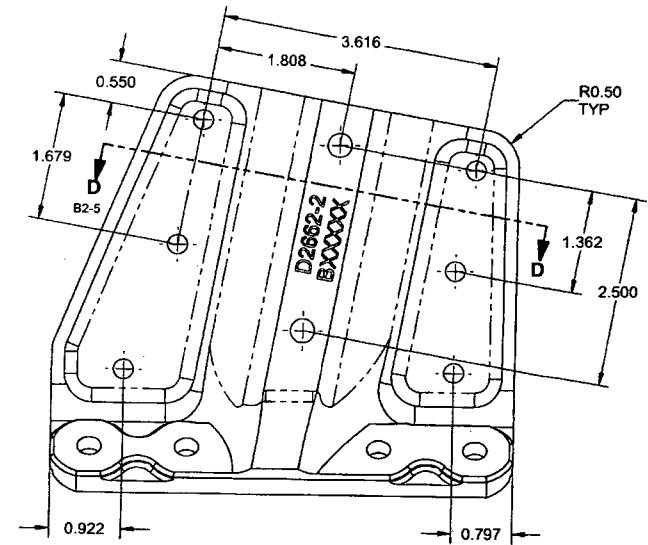
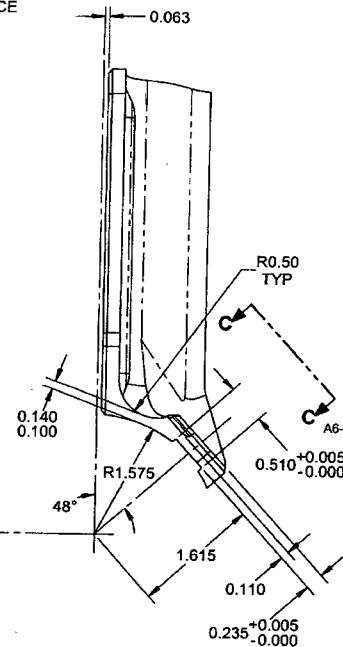
4.632

1.00

0.687

80°

2.727



D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BLLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	<i>00</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	REV. E
DRAWN	<i>00</i>		SHEET 4 OF 5
CHECKED	<i>AS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

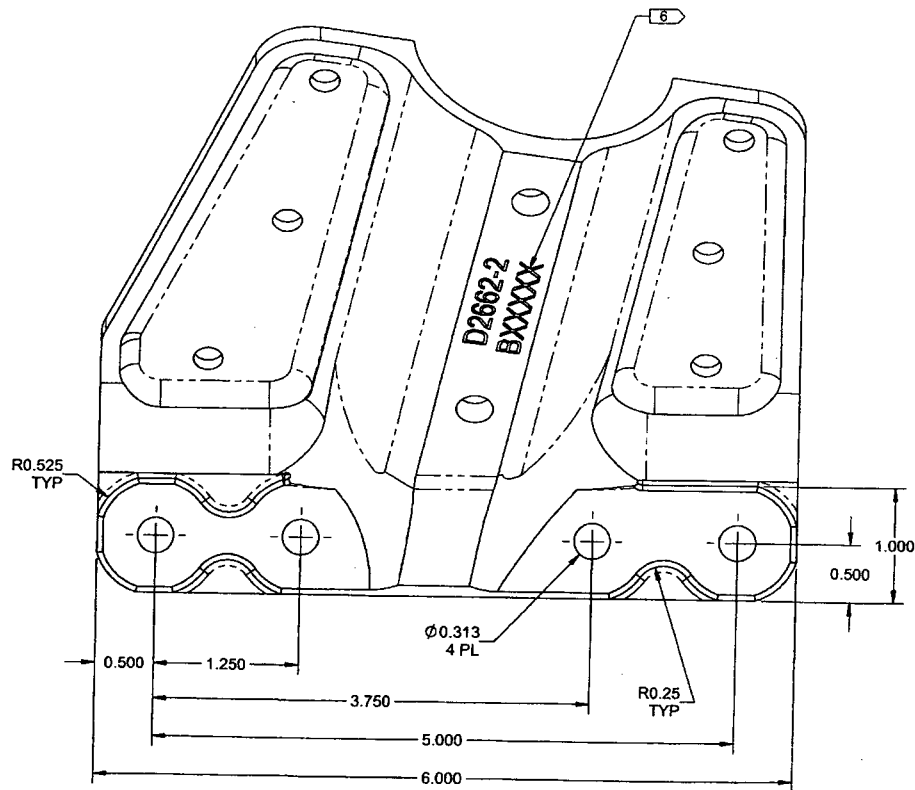
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

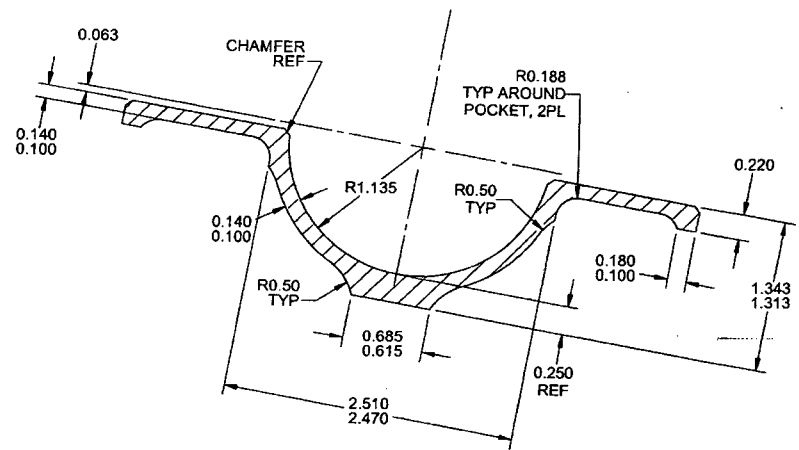
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

80992



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
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DART AEROSPACE LTD		Work Order:	80992
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	A6	A7	A8	A9	A10
A	3.611	3.621		3.612	3.613	3.613	3.614	3.613
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.501	2.5	2.5	2.5	2.5
E	1.674	1.684		1.677	1.679	1.68	1.679	1.679
F	0.100	0.140		.125	.125	.125	.124	.124
G	0.210	0.230		.224	.223	.224	.221	.223
H	0.615	0.685		.675	.675	.667	.671	.671
I	2.470	2.510		2.490	2.490	2.490	2.491	2.491
J	1.313	1.343		1.323	1.323	1.323	1.323	1.323
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.140	1.139	1.137	1.136	1.136
N	0.100	0.180		.145	.147	.145	.141	.141
O	0.100	0.145		.114	.115	.115	.115	.115
P	0.240	0.260		.250	.247	.251	.250	.250
Q	0.677	0.697		.689	.687	.686	.687	.687
R	0.540	0.560		.552	.550	.550	.550	.550
S	0.912	0.932		.921	.923	.923	.923	.923
T	0.787	0.807		.801	.799	.798	.798	.799
U	5.990	6.010		6.001	6.001	6.003	6.003	6.003
V	4.995	5.005		5.000	5.001	4.999	5.000	5.001
W	0.490	0.510		.501	.499	.498	.499	.499
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.001	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.251	1.25	1.25	1.25
AB	0.490	0.510		.500	.501	.503	.501	.501
AC	3.745	3.755		3.751	3.749	3.750	3.750	3.75
AD	0.100	0.140		.124	.130	.127	.132	.132
AE	0.235	0.240		.240	.240	.240	.240	.240
AF	0.510	0.515		.510	.510	.511	.511	.511
AG	0.100	0.120		.115	.115	.115	.115	.115
AH								
AI								

QC2 - 25 12-05-13

QL8 on 12/05/23

DART AEROSPACE LTD		Work Order: 80992
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
A	3.811	3.821		3.613	3.613	3.613	3.613	3.613
B	0.256	0.263		0.257	0.257	0.257	0.257	0.257
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.678	1.678	1.678	1.678	1.678
F	0.100	0.140		0.124	0.125	0.125	0.125	0.124
G	0.210	0.230		0.219	0.221	0.219	0.220	0.220
H	0.615	0.685		0.675	0.675	0.675	0.675	0.675
I	2.470	2.510		2.491	2.490	2.490	2.490	2.490
J	1.313	1.343		1.327	1.328	1.328	1.327	1.328
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.137	1.138	1.136	1.136	1.136
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.108	0.110	0.108	0.112	0.109
P	0.240	0.260		0.250	0.250	0.250	0.250	0.250
Q	0.677	0.697		0.687	0.684	0.687	0.683	0.682
R	0.540	0.560		0.549	0.548	0.549	0.550	0.550
S	0.912	0.932		0.922	0.920	0.920	0.922	0.921
T	0.787	0.807		0.796	0.795	0.797	0.795	0.797
U	5.990	6.010		6.001	6.000	6.000	6.000	6.000
V	4.995	5.005		5.001	5.000	5.000	5.000	5.000
W	0.490	0.510		0.500	0.498	0.497	0.495	0.498
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		0.999	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.248	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.498	0.499	0.500	0.500	0.500
AC	3.745	3.755		3.751	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.125	0.125	0.125	0.125	0.125
AE	0.235	0.240		0.238	0.240	0.240	0.238	0.239
AF	0.510	0.515		0.514	0.514	0.514	0.514	0.514
AG	0.100	0.120		0.112	0.112	0.115	0.115	0.113
AH								
AI								

QC2 - 17

QC 8 OK 12/05/23

DART AEROSPACE LTD		Work Order:	80992
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#16	#17	#18	#19	#20
A	3.611	3.621		3.613	3.613	3.613	3.613	3.613
B	0.256	0.263		0.257	0.257	0.257	0.257	0.257
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.125	0.123	0.122	0.121	0.123
G	0.210	0.230		0.221	0.220	0.219	0.217	0.217
H	0.615	0.685		0.675	0.675	0.675	0.675	0.675
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.327	1.327	1.328	1.328	1.328
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.128	1.125	1.134	1.134	1.134
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.118	0.118	0.129	0.128	0.129
P	0.240	0.260		0.250	0.250	0.250	0.250	0.250
Q	0.677	0.697		0.684	0.684	0.681	0.683	0.687
R	0.540	0.560		0.552	0.551	0.552	0.552	0.552
S	0.912	0.932		0.922	0.923	0.921	0.922	0.922
T	0.787	0.807		0.797	0.796	0.796	0.796	0.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.498	0.495	0.499	0.496	0.503
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.499	0.495	0.499	0.499	0.502
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.131	0.130	0.127	0.127	0.128
AE	0.235	0.240		0.239	0.239	0.238	0.238	0.239
AF	0.510	0.515		0.514	0.514	0.514	0.514	0.514
AG	0.100	0.120		0.113	0.115	0.113	0.115	0.113
AH								
AI								

QC 2 - 10

QC 8 and 12/05/23

DART AEROSPACE LTD		Work Order:	80992
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	3.611	3.621		3.613				
B	0.256	0.263		0.257				
C	0.315	0.322		0.316				
D	2.495	2.505		2.500				
E	1.674	1.684		1.679				
F	0.100	0.140		0.122				
G	0.210	0.230		0.219				
H	0.615	0.685		0.675				
I	2.470	2.510		2.490				
J	1.313	1.343		1.328				
K	0.178	0.198		0.188				
L	0.470	0.530		0.500				
M	1.125	1.145		1.132				
N	0.100	0.180		0.135				
O	0.100	0.145		0.128				
P	0.240	0.260		0.250				
Q	0.677	0.697		0.683				
R	0.540	0.560		0.551				
S	0.912	0.932		0.923				
T	0.787	0.807		0.796				
U	5.990	6.010		6.000				
V	4.995	5.005		5.000				
W	0.490	0.510		0.499				
X	0.312	0.319		0.314				
Y	0.990	1.010		1.000				
Z								
AA	1.245	1.255		1.250				
AB	0.490	0.510		0.499				
AC	3.745	3.755		3.750				
AD	0.100	0.140		0.129				
AE	0.235	0.240		0.239				
AF	0.510	0.515		0.514				
AG	0.100	0.120		0.113				
AH								
AI								

QC 2 - 10

QC 8 and 12/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries